

cylindrical circumferential surface of said roll of paper such that said outer straight cylindrical circumferential surface of said roll of paper forms an angle with said outer circumferential surface of said pressed curled portion that is greater than 0° and less than 180° and faces away from said axis of said roll of paper, and wherein said pressed curled portion is formed by inwardly curling a respective edge of said at least one of said two open ends while the adhesive between said plural wound layers is in a non-cured state.

9. *(Twice Amended)* A fiber drum comprising:

a roll of paper having an axis, two open ends and an outer straight cylindrical circumferential surface, plural wound layers with a cured adhesive between said plural wound layers, and a pressed curled portion each of said two open ends such that said pressed curled portion is more dense than said plural wound layers, said pressed curled portion having an outer circumferential surface, wherein said pressed curled portion is angled radially outwardly relative to said outer straight cylindrical circumferential surface of said roll of paper such that said outer straight cylindrical circumferential surface of said roll of paper forms an angle with said outer circumferential surface of said pressed curled portion that is greater than 0° and less than 180° and faces away from said axis of said roll of paper, and wherein said pressed curled portion is formed by inwardly curling a respective edge of said at least one of said two open ends while the adhesive between said plural wound layers is in a non-cured state;

a paper material cover plate detachably joined to said pressed curled portion at one of said two open ends such that the opening at said one of said two open ends is closed; and

a paper material bottom plate fixedly joined to said pressed curled portion at the other of said two open ends such that the opening at said other of said two open ends is closed.

10. *(Twice Amended)* A fiber drum comprising:

a roll of paper having an axis, two open ends and an outer straight cylindrical circumferential surface, plural wound layers with a cured adhesive between said plural wound layers, and a pressed curled portion at each of said two open ends such that said pressed curled portion is more dense than

2
said plural wound layers, said pressed curled (portion) having an outer circumferential surface, wherein said pressed curled (portion) is angled radially outwardly relative to said outer straight cylindrical circumferential surface of said roll of paper such that said outer straight cylindrical circumferential surface of said roll of paper forms an angle with said outer circumferential surface of said pressed curled portion that is greater than 0° and less than 180° and faces away from said axis of said roll of paper, and wherein said pressed curled portion is formed by inwardly curling a respective edge of said at least one of said two open ends while the adhesive between said plural wound layers is in a non-cured state;

3
a paper material cover plate detachably joined to said pressed curled portion at one of said two open ends such that the opening at said one of said two open ends is closed; and

a paper material bottom plate fixedly joined to said pressed curled portion at the other of said two open ends such that the opening at said other of said two open ends is closed, wherein the pressed curled portion at said other of said two open ends is formed by inwardly curling the edge of said other of said two open ends together with a circumferential edge of said paper material bottom plate, while the adhesive between said plural wound layers is in a non-cured state, to fixedly join said edge of said other of said two open ends to said paper material bottom plate.

Kindly add the following new claims 14-19:

3
14. The cylindrical body as recited in claim 6, wherein said curled portion includes an inner circumferential surface defining a line that is tangent thereto and parallel to said axis of said roll of paper, and wherein said roll of paper has an inner cylindrical surface defining a line that is parallel to said axis of said roll of paper, with a radial distance between the line that is tangent to said inner circumferential surface of said curled portion and the line defined by the inner cylindrical surface of said roll of paper being no greater than 1mm.

15/ The cylindrical body as recited in claim 14, wherein the line that is tangent to said inner circumferential surface of said curled portion is not radially further from said axis of said roll of paper than is the line defined by the inner cylindrical circumferential surface of said roll of paper.

16. The cylindrical body as recited in claim 9, wherein said curled portion includes an inner circumferential surface defining a line that is tangent thereto and parallel to said axis of said roll of paper, and wherein said roll of paper has an inner cylindrical surface defining a line that is parallel to said axis of said roll of paper, with a radial distance between the line that is tangent to said inner circumferential surface of said curled portion and the line defined by the inner cylindrical surface of said roll of paper being no greater than 1mm.

17. The cylindrical body as recited in claim 16, wherein the line that is tangent to said inner circumferential surface of said curled portion is not radially further from said axis of said roll of paper than is the line defined by the inner cylindrical circumferential surface of said roll of paper.

18. The cylindrical body as recited in claim 10, wherein said curled portion includes an inner circumferential surface defining a line that is tangent thereto and parallel to said axis of said roll of paper, and wherein said roll of paper has an inner cylindrical surface defining a line that is parallel to said axis of said roll of paper, with a radial distance between the line that is tangent to said inner circumferential surface of said curled portion and the line defined by the inner cylindrical surface of said roll of paper being no greater than 1mm.

19. The cylindrical body as recited in claim 18, wherein the line that is tangent to said inner circumferential surface of said curled portion is not radially further from said axis of said roll of paper than is the line defined by the inner cylindrical circumferential surface of said roll of paper.